

Standards

DIN 8555	MF5-GF-45-T
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Characteristics CARBO F-864 is a flux cored wire electrode, which produces a heat and thermal shock resistant deposit.
Used for hot working tools subject to high mechanical, thermal and abrasive loads.
The electrode is designed for maintenance of hot working tools and to increase their service life.

Procedure Preheating temperature of 400°C on tools should be maintained.

Typical applications Repair of high quality hot working tools

Mechanical properties of all-weld metal
(typical values)

Hardness HRc
45-48

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Mo	W	V	Ti	Fe
0,25	0,5	0,6	5,0	1,5	1,4	0,5	+	balance

Gas types EN 439 M 1 and M 2

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	110 - 180	G
1,6	1/16	20 - 26	150 - 250	G

Delivering form **O = Flux cored wire self shielding**
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coiling / Weight B/BS 300 = 15 kg B 450 = 30 kg Pay off pack = 150/ 300 kg

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